

Date: Tuesday, 02/06/2009 2:36:40 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SHOULDER HARNESS KIT
<b>Job Number</b>	: 48314		
<b>Estimate Number</b>	: 13048		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D350764011
<b>This Issue</b>	: 02/06/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: N/A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 47785	<b>Drawing Revision</b>	: B
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>MF 09-06-02</u>	<b>Due Date</b>	: 03/06/2009
<b>Comment</b>	EST REV:A New issue 07-10-11 DD verified by EC Est Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD est Rev C ncr 09-059 09.05.25 EC verified by:DD		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-764-011 CHG002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0 D2854 3/4" Velcro Strip



Comment: Qty.: 2.6660 f(s)/Unit Total : 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-1-080 (8) each as per dwg D2854

Batch: 47604

4.0 D2854 3/4" Velcro Strip



Comment: Qty.: 2.6660 f(s)/Unit Total : 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-3-080 (8) each as per dwg D2854

Batch: 47604

5.0 D3578041 Doubler



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

DOUBLER

batch: B47143

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 48314

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3636041

Shoulder Harness



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SHOULDER HARNESS

batch

B46198

SS 09/06/03 (X)

7.0

D3637041

Bracket Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET ASSEMBLY

batch

B43353 x2 B47869 x2

SS 09/06/03 (X)

8.0

D36373

Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch

B43184

SS 09/06/03 (X)

9.0

D36381

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BUSHING

batch

B45846

SS 09/06/03 (X)

10.0

D36391

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch

B45828

SS 09/06/03 (X)

11.0

D36392

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch

B42299

SS 09/06/03 (X)

12.0

D36393

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch

35382

SS 09/06/03 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D36394

Doubler



Comment: Qty.: 10000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch

B35383

SS 09/06/03 (X)

14.0

D36401

Belt Guide



Comment: Qty.: 20000 Each(s)/Unit Total : 2.0000 Each(s)

BELT GIUDE

batch

B46656

SS 09/06/03 (X)

15.0

D36403

Belt Guide



Comment: Qty.: 20000 Each(s)/Unit Total : 2.0000 Each(s)

BELT GIUDE

batch

B46657

SS 09/06/03 (X)

16.0

D36411

Cover



Comment: Qty.: 20000 Each(s)/Unit Total : 2.0000 Each(s)

COVER

batch

45829

SS 09/06/03 (X)

17.0

D36413

Cover



Comment: Qty.: 10000 Each(s)/Unit Total : 1.0000 Each(s)

COVER

batch

43232

SS 09/06/03 (X)

18.0

D36414

Cover



Comment: Qty.: 10000 Each(s)/Unit Total : 1.0000 Each(s)

COVER

batch

B45497

SS 09/06/03 (X)

19.0

D36421

Doubler



Comment: Qty.: 20000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

batch

B43234

SS 09/06/03 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D36431

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

batch

B34547

SS 09/06/03 (X)

21.0

D36432

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

batch

B34548

SS 09/06/03 (X)

22.0

D36441

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SHIM

batch

B35392

SS 09/06/03 (X)

23.0

D36571

Guide Tool



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GUIDE TOOL

batch

B34550

SS 09/06/03 (X)

24.0

ALS41032130

Insert



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Insert

batch

B34550

M110511

SS 09/06/03 (X)

25.0

AN33A

Bolt



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

batch

M11925

SS 09/06/03 (X)

26.0

AN36A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch

M109752

SS 09/06/03 (X)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M108986

SS 09/06/03 (X1)

28.0

AN960JD10

Washer



Comment: Qty.: 48.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

batch

M111279

SS 09/06/03 (X1)

29.0

AN960JD916

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M109174

SS 09/06/03 (X1)

30.0

AN9706

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M109798

SS 09/06/03 (X1)

31.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Cherry Rivet

batch

M111548

SS 09/06/03 (X1)

32.0

CR321242

Cherry Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cherry Rivet

batch

M110806

SS 09/06/03 (X1)

33.0

CR3212504

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M106321

SS 09/06/03 (X1)



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Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

CR3212507

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

M105978

SS 09/06/03 (X1)

35.0

MS20426AD33

Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

batch

M7681

SS 09/06/03 (X1)

36.0

MS20426AD44

Rivet



Comment: Qty.: 106.0000 Each(s)/Unit Total : 106.0000 Each(s)

Rivet

batch

M15541

SS 09/06/03 (X1)

37.0

MS20426AD46

Rivet



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Rivet

batch

M105144

SS 09/06/03 (X1)

38.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet, Universal Head

batch

M109371

SS 09/06/03 (X1)

39.0

MS21059L3

Nut Plate



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

batch

M109962

SS 09/06/03 (X1)

40.0

MS21072L3

Nutplate



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nutplate

batch

M110002

SS 09/06/03 (X1)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS35206267

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch

M109389

SS 09/06/03 (X)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/06/03 (X)

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-764-011

Location:

PPP Rev:

Rev B

SS 09/06/04 (X)

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/04

Job Completion



ME 09-06-04